Amendments to the Claims:

This listing of claims will replace all prior versions, and listings, of claims in the application:

Listing of Claims:

1. (cancelled)

2. (new) A method of controlling flare, comprising:

moving a material through a roll-forming process; and

automatically varying a position of a roller to change a flare characteristic of the material as the material moves through the roll-forming process.

3. (new) A method as defined in claim 2, wherein the material is at least one of a formed component, a strip material, and a sheet material.

4. (new) A method as defined in claim 2, further comprising:

obtaining a flare measurement value associated with the material and a flare tolerance value;

comparing the flare measurement value to the flare tolerance value; and

determining a roller position value based on the comparison of the flare measurement value and the flare tolerance value.

5. (new) A method as defined in claim 4, further comprising storing the roller position value in a database.

6. (new) A method as defined in claim 5, wherein the roller position value may be retrieved from the database based on material identification information associated with the material.

7. (new) A method as defined in claim 4, wherein automatically varying the position of the roller includes automatically varying the position of the roller in response to the comparison of the flare measurement value and the flare tolerance value.

8. (new) A method as defined in claim 4, wherein the flare measurement value is associated with at least one of a flare-in condition and a flare-out condition.

9. (new) A method as defined in claim 2, further comprising determining a location of the material within the roll-forming process.

10. (new) A method as defined in claim 9, wherein automatically varying the position of the roller includes automatically varying the position of the roller based on the location of the material within the roll-forming process.

11. (new) A method as defined in claim 2, wherein the material includes at least one of a C-shaped component and a Z-shaped component.

12. (new) A method as defined in claim 2, wherein automatically varying the position of the roller includes automatically varying the position of the roller in accordance with at least one of a desired roller velocity, a desired roller ramp rate, and a desired roller acceleration.

13. (new) A method as defined in claim 2, wherein automatically varying the position of the roller includes automatically varying an angle of the roller.

14. (new) A method as defined in claim 2, wherein automatically varying the position of the roller includes automatically varying the position of the roller based on a material characteristic of the material.

15. (new) An apparatus for controlling flare, comprising:

a processor system including a memory; and

instructions stored in the memory that enable the processor system to:

detect a material moving through a roll-forming process; and

automatically vary a position of a roller to change a flare characteristic of the material as the material moves through the roll-forming process.

16. (new) An apparatus as defined in claim 15, wherein the material is at least one of a formed component, a strip material, and a sheet material.

17. (new) An apparatus as defined in claim 15, wherein the instructions stored in the memory enable the processor system to:

obtain a flare measurement value associated with the material and a flare tolerance value;

compare the flare measurement value to the flare tolerance value; and

determine a roller position value based on the comparison of the flare measurement value and the flare tolerance value.

18. (new) An apparatus as defined in claim 17, wherein the instructions stored in the memory enable the processor system to store the roller position value in a database.

19. (new) An apparatus as defined in claim 18, wherein the instructions stored in the memory enable the processor system to retrieve the roller position value from the database based on material identification information associated with the material.

20. (new) An apparatus as defined in claim 17, wherein the instructions stored in the memory enable the processor system to automatically vary the position of the roller in response to the comparison of the flare measurement value and the flare tolerance value.

21. (new) An apparatus as defined in claim 17, wherein the flare measurement value is associated with at least one of a flare-in condition and a flare-out condition.

22. (new) An apparatus as defined in claim 15, wherein the instructions stored in the memory enable the processor system to determine a location of the material within the roll-forming process.

23. (new) An apparatus as defined in claim 22, wherein the instructions stored in the memory enable the processor system to automatically vary the position of the roller based on the location of the material within the roll-forming process.

24. (new) An apparatus as defined in claim 15, wherein the material includes at least one of a C-shaped component and a Z-shaped component.

25. (new) An apparatus as defined in claim 15, wherein the instructions stored in the memory enable the processor system to automatically vary the position of the roller in accordance with at least one of a desired roller velocity, a desired roller ramp rate, and a desired roller acceleration.

26. (new) An apparatus as defined in claim 15, wherein the instructions stored in the memory enable the processor system to automatically vary an angle of the roller.

27. (new) An apparatus as defined in claim 15, wherein the instructions stored in the memory enable the processor system to automatically vary the position of the roller based on a material characteristic of the material.

28. (new) A machine accessible medium having instructions stored thereon that, when executed, cause a machine to:

detect a material moving through a roll-forming process; and

automatically vary a position of a roller to change a flare characteristic of the material as the material moves through the roll-forming process.

29. (new) A machine accessible medium as defined in claim 28, wherein the material is at least one of a formed component, a strip material, and a sheet material.

30. (new) A machine accessible medium as defined in claim 28 having instructions stored thereon that, when executed, cause the machine to:

obtain a flare measurement value associated with the material and a flare tolerance value;

compare the flare measurement value to the flare tolerance value; and

determine a roller position value based on the comparison of the flare measurement value and the flare tolerance value.

31. (new) A machine accessible medium as defined in claim 30 having instructions stored thereon that, when executed, cause the machine to store the roller position value in a database.

32. (new) A machine accessible medium as defined in claim 31 having instructions stored thereon that, when executed, cause the machine to retrieve the roller position value from the database based on material identification information associated with the material.

33. (new) A machine accessible medium as defined in claim 30 having instructions stored thereon that, when executed, cause the machine to automatically vary the position of the roller in response to the comparison of the flare measurement value and the flare tolerance value.

34. (new) A machine accessible medium as defined in claim 30, wherein the flare measurement value is associated with at least one of a flare-in condition and a flare-out condition.

35. (new) A machine accessible medium as defined in claim 28 having instructions stored thereon that, when executed, cause the machine to determine a location of the material within the roll-forming process.

36. (new) A machine accessible medium as defined in claim 35 having instructions stored thereon that, when executed, cause the machine to automatically vary the position of the roller based on the location of the material within the roll-forming process.

37. (new) A machine accessible medium as defined in claim 28, wherein the material includes at least one of a C-shaped component and a Z-shaped component.

38. (new) A machine accessible medium as defined in claim 28 having instructions stored thereon that, when executed, cause the machine to automatically vary the position of the roller in accordance with at least one of a desired roller velocity, a desired roller ramp rate, and a desired roller acceleration.

39. (new) A machine accessible medium as defined in claim 28 having instructions stored thereon that, when executed, cause the machine to automatically vary an angle of the roller.

40. (new) A machine accessible medium as defined in claim 28 having instructions stored thereon that, when executed, cause the machine to automatically vary the position of the roller based on a material characteristic of the material.

41. (new) A system for controlling flare, comprising:

a roller configured to vary a flare characteristic of a material; and

a position adjustment system operatively coupled to the roller and configured to automatically adjust the roller to condition the flare characteristic of the material.

42. (new) A system as defined in claim 41, wherein the material is at least one of a formed component, a strip material, and a sheet material.

43. (new) A system as defined in claim 41, wherein the position adjustment system is configured to automatically adjust the roller based on a location of the material.

44. (new) A system as defined in claim 41, further comprising a processor system communicatively coupled to the position adjustment system and configured to cause the position adjustment system to adjust the roller.

45. (new) A system as defined in claim 44, further comprising a sensor communicatively coupled to the processor system, wherein the sensor is configured to generate location information associated with the location of the material and convey the location information to the processor system.

46. (new) A system as defined in claim 44, further comprising a sensor communicatively coupled to the processor system and configured to generate a flare measurement value associated with the flare characteristic of the material.

47. (new) A system as defined in claim 46, wherein the sensor includes at least one of a linear voltage displacement transducer, an optical sensor, a laser sensor, a proximity sensor, and an ultrasonic sensor.

48. (new) A system as defined in claim 46, wherein the sensor is a feedback sensor configured to generate the flare measurement value after the flare characteristic of the material is varied by the roller.

49. (new) A system as defined in claim 46, wherein the position adjustment system is configured to automatically adjust the roller based on the flare measurement value.

50. (new) A system as defined in claim 41, wherein the position adjustment system includes at least one of a servo motor, a stepper motor, a hydraulic motor, a pneumatic piston, and a threaded rod.

51. (new) A system as defined in claim 41, further comprising a linear encoder operatively coupled to the position adjustment system and configured to generate a measurement value associated with a position of the roller.

52. (new) A system for controlling flare in a roll-forming process, comprising:

a storage interface configured to retrieve a roller position value from a memory; and

a flange roller adjuster communicatively coupled to the storage interface and configured to obtain the roller position value from the storage interface and change a position of a roller based on the roller position value.

53. (new) A system as defined in claim 52, further comprising:

a comparator communicatively coupled to the storage interface and configured to obtain a flare tolerance value from the storage interface; and

a sensor interface communicatively coupled to the comparator and configured to communicate a flare measurement value to the comparator, wherein the comparator is configured to compare the flare tolerance value to the flare measurement value, and wherein the roller position value is determined based on the comparison of the flare tolerance value and the flare measurement value.

54. (new) A system as defined in claim 53, wherein the sensor interface is configured to be communicatively coupled to at least one of a linear voltage displacement transducer, an optical sensor, a laser sensor, a proximity sensor, and an ultrasonic sensor.

55. (new) A system as defined in claim 52, wherein the flange roller adjuster is configured to be communicatively coupled to a position adjustment system and a linear encoder.

56. (new) A system as defined in claim 52, further comprising a component position detector configured to detect a component.

57. (new) A system as defined in claim 56, wherein the flange roller adjuster is configured to change the position of the roller in response to the component position detector detecting the component.